

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026818**Date Inspected:** 02-Dec-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Watson Bowman ACME**Location:** Buffalo, NY**CWI Name:** Reno Davis, John Crabtree**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Hinge A**Summary of Items Observed:**

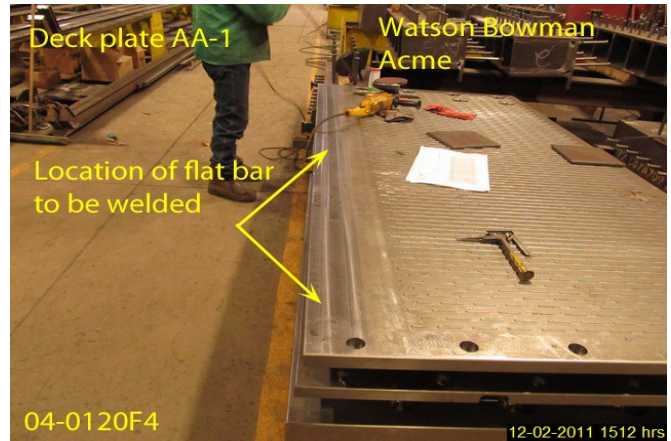
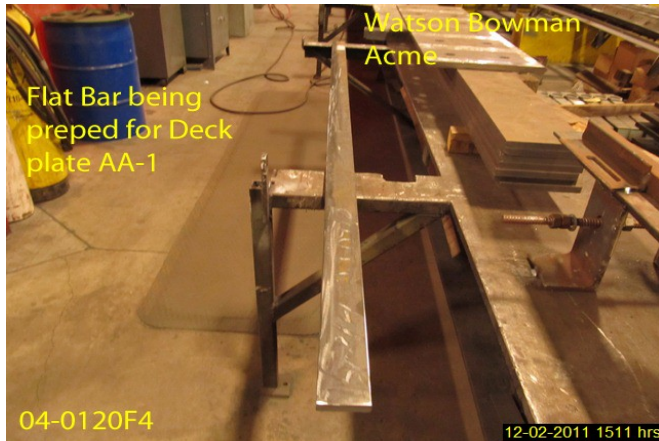
On this date, Quality Assurance Inspector (QAI) Kenneth Riley was present at the Watson Bowman Acme Corporation (WBA) facility, as requested, in Buffalo, New York to observe fabrication activities of the Seismic Expansion Joint Hinge A lanes for the San Francisco Oakland Bay Bridge (SFOBB) project.

This (QAI) Inspector met with Watson Bowman Acme Corporation (WBA) Quality Control (QCS) Supervisor John Miller and KTA-Tator (ABF Representative), Certified Welding Inspectors (CWI), Mr. John Crabtree. ABF Representatives are the Quality Control personnel for this location.

This QAI arrived at WBA and observed Joe Kearns performing Flux Core Arc Welding (FCAW) on components SEI112667-CA2-16, using Hobart (Tri-Mark) TM-811N1 electrode under WPS's FCAW-NY-16 (CJP for Joint TC-U5a-GF), and FCAW-13 (CJP for joint TC-U4b-GF). The welder was observed using a rose bud torch to pre-heat the areas to 107 degrees Celsius (225F). The 10mm fillet weld for weld numbers 2~6 B&E and 1E & 7B. These welds on the channel boxes join the back plate to the stiffeners. Also noted was welders John Ash and Jayson Gray was fitting up the 75mm x 19mm flat bar to deck plates SEI112667AA-1 and AB-1. This QAI along with ABF Representative John Crabtree verified the placement of the Flat bars and spoke with the welders concerning the welding process to be used should be SMAW due to the weld being 6mm and single pass. The preheat will 250 degrees bases on the 82mm thickness of the deck plates. QC personnel John Crabtree was observed onsite and monitoring the welding of these joints. Mr. Crabtree was also noted as checking the welding parameters for compliance to the Welding Procedure Specification (WPS). Mr. Crabtree was filling in for Mr. Reno Davis whom was off this day. There was no welding on the night shift this day.

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Summary of Conversations:

Basic conversation, fundamental to completion of the tasks at hand, occurred between this QAI, ABF QC, and WBA personnel .

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Riley, Ken	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
